

# इंटरनेट

# मानक

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“Step Out From the Old to the New”

IS 13741-6 (1993): Carbide Tips, Part 6: Carbide Tips for Single Point Threading Tools [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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IS 13741 ( Part 6 ) : 1993

( Superseding IS 2162 : 1979 )

( Reaffirmed 2003 )

भारतीय मानक

कार्बाइड टिप

भाग 6 एक नोक वाले चूड़ीदार औजारों के लिए कार्बाइड टिप — विशिष्ट

*Indian Standard*

CARBIDE TIPS

PART 6 CARIDE TIPS FOR SINGLE POINT THREADING TOOLS — SPECIFICATION

UDC 621.99 [ 699.018.25 ]

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**BUREAU OF INDIAN STANDARDS**

MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG

NEW DELHI 110002

July 1993

Price Group 2

## FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards, after the draft finalized by the Single Point Cutting Tools, Carbide Tips and Indexable Inserts Sectional Committee had been approved by the Production Engineering Division Council.

Dimensions and other requirements of carbide tips for cutting tools were covered in different Indian Standards are listed below:

- IS 2162 : 1979 Dimensions for carbide tips for single point tools
- IS 8065 : 1976 Specification for carbide tips for light cutting operations
- IS 8301 : 1976 Dimensions for carbide tips for drills with point angle 115° ( Type AB )
- IS 9327 : 1979 Dimensions for carbide tips for reamers, core drills, end mills and slot milling cutters
- IS 12294 : 1988 Dimensions of carbide tips for parting off and turning tools for sliding head type automats ( IND 5 and IND 6 )

It has been decided to cover all the above carbide tips under one Indian Standard in different parts for quick and ease of reference. Hence all the above standards have been combined in one standard having seven parts. Carbide tips for round nose turning tools have also been covered in part seven of the standard. The other Indian Standards on carbide tips of this series are:

- IS 13741 ( Part 1 ) Carbide tips for single point tools
- IS 13741 ( Part 2 ) Carbide tips for single point tools for light cutting operations
- IS 13741 ( Part 3 ) Carbide tips for single point tool blanks for sliding head type automats
- IS 13741 ( Part 4 ) Carbide tips for multi point tools
- IS 13741 ( Part 5 ) Carbide tips for twist drills with point angle 115°
- IS 13741 ( Part 7 ) Carbide tips for single point round nose turning tools

This standard supersedes IS 2162 : 1979.

The types have been so arranged in different parts so that review and updating becomes easier when the referred ISO or national standard is updated.

These tips are used on single point threading tools covered in:

- IS 8778 : 1978 Single point carbide tipped external threading tools ( IND 2 )  
( 55 or 60 degree )
- IS 10969 : 1984 Single point carbide tipped internal threading tools ( IND 3 )  
( 55 or 60 degree )

The committee responsible for the preparation of this standard is given at Annex A.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off the numerical values ( revised )'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

# *Indian Standard*

## CARBIDE TIPS

### PART 6 CARBIDE TIPS FOR SINGLE POINT THREADING TOOLS — SPECIFICATION

#### 1 SCOPE

This standard covers the dimensions and other requirements for carbide tips for single point threading tools.

#### 2 REFERENCE

IS 2428 : 1964 Application of carbides for machining, ranges of application and colour code is necessary adjuncts to this standard.

#### 3 TYPES

Carbide tips for single point threading tools shall be of following types:

Type TL

Type TR

#### 4 DIMENSIONS

Dimensions of carbide tips shall be as given in Table 1 read with figure.

#### 5 GENERAL REQUIREMENTS

5.1 The bottom edges may be provided with a chamfer.

5.2 Tips having a thickness less than 4 mm are supplied without chamfer or radius.

5.3 Carbide tips shall be free from cracks.

#### 6 DESIGNATION

Carbide tips shall be designated by carbide tip type, length l, IS No. and Part No. and range of application as per IS 2428 : 1964.

Carbide tip of type TR having length ( l ) 16 mm, and with range of application K20 and conforming to this standard shall be designated as:

Carbide Tip IS 13741 ( Part 6 ) TR16 K20

#### 7 MARKING

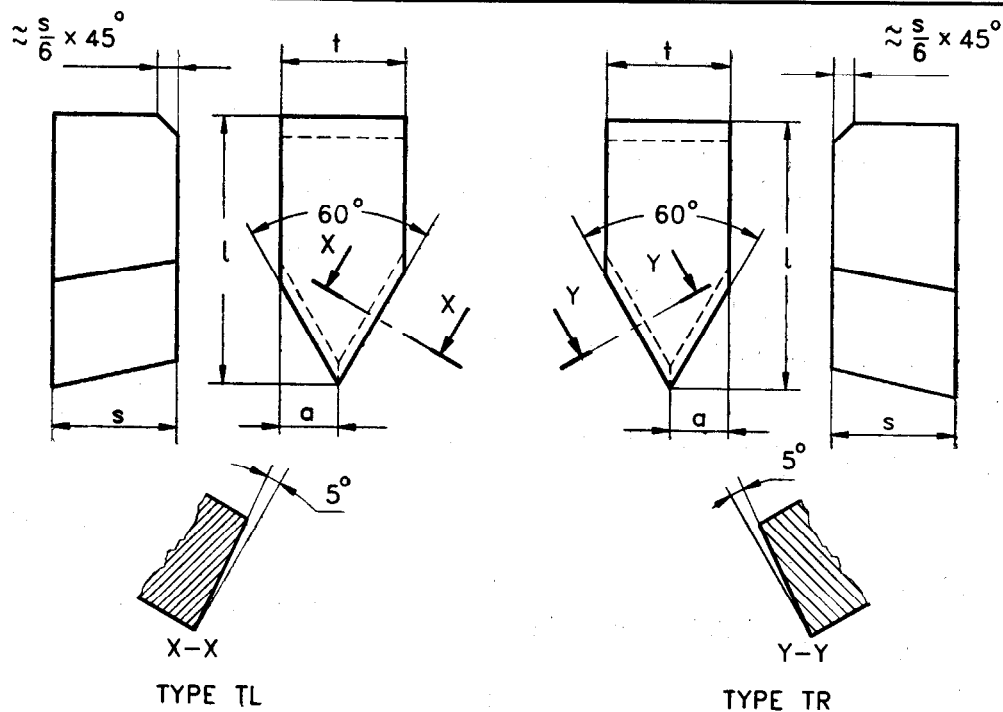
Shall be marked with designation, manufacturer's name or trade mark on the carton.

#### 8 PACKAGING

The carbide tips shall be suitably packed to avoid damage in handling and transit.

**Table 1 Dimensions of Carbide Tips for Single Point Threading Tools**  
( Clause 4 )

All dimensions in millimetres.



| $l$  |             | $t$  |             | $s$  |             | $a$ |
|------|-------------|------|-------------|------|-------------|-----|
| Size | Tol.        | Size | Tol.        | Size | Tol.        |     |
| 12   | $+0.4$<br>0 | 3    | $+0.3$<br>0 | 3    | $+0.3$<br>0 | 1   |
| 14   | $+0.6$<br>0 | 4    |             | 4    |             | 1.2 |
| 16   |             | 5    |             | 5    |             | 1.5 |
| 18   |             | 6    |             | 6    |             | 2.5 |
| 20   |             | 9    | $+0.4$<br>0 | 9    | $+0.4$<br>0 | 4   |

## ANNEX A

### ( Foreword )

#### COMMITTEE COMPOSITION

Single Point Cutting Tools, Carbide Tips and Indexable Inserts Sectional Committee, PE 12

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Doc : No PE 12 ( 5391 )

### Amendments Issued Since Publication

| Amend No. | Date of Issue | Text Affected |
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## BUREAU OF INDIAN STANDARDS

### Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002  
Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha  
( Common to all Offices )

### Regional Offices :

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg  
NEW DELHI 110002

Eastern : 1/14 C. I. T. Scheme VII M, V. I. P. Road, Maniktola  
CALCUTTA 700054

Northern : SCO 445-446, Sector 35-C, CHANDIGARH 160036

Southern : C. I. T. Campus, IV Cross Road, MADRAS 600113

Western : Manakalaya, E9 MIDC, Marol, Andheri ( East )  
BOMBAY 400093

Branch : AHMADABAD. BANGALORE. BHOPAL. BHUBANESHWAR. COIMBATORE.  
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LUCKNOW. PATNA. THIRUVANANTHAPURAM.

### Telephone

{ 331 01 31  
{ 331 13 75

{ 37 84 99, 37 85 61  
{ 37 86 26, 37 86 62

{ 53 38 43, 53 16 40  
{ 53 23 84

{ 235 02 16, 235 04 42  
{ 235 15 19, 235 23 15

{ 632 92 95, 632 78 58  
{ 632 78, 91, 632 78 92